*Work Order ID 117786 May-02-14 8:41:54 AM			*117	7786*						Page 1
Item ID: D3580 Revision ID: Item Name: Joggle)-1 Bracket		Accept	*N900	040	100)* s	etup Sta	·· 1\(\frac{1}{2}\)	S1* S2*
Start Date: 5/02/1 Required Date: 5/02/1 Reference:	4 Start Qty: 3.00	*3*		Cust Item l Customer:	ID:				· IN	·>/"
Approvals: Proc QC:	ess Plan:	Date:	Tooling: SPC (Y/N):		ate:		F	tun Sta Sto	· "IV	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3580	Rev B	•								
100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as r	per Dwg D3580	0.00				<u>3</u>	0	_	Ju14-05-2
304.00	Dwg Rev: Prog Rev:	: <i>1</i> 5_								
110	QC2- Inspect parts off	machine FAI/FAIB	0.00							
110 QC Quality Control	Мето		0.00				3	٥	<u>.</u>	JM14.05-2
120	QC8- Inspect parts - se	econd check	0.00					•		DAS 9
120	Memo		0.00				(3)	19-6	2.09	- 9.8 9

Memo

Quality Control

Work Ord May-02-14 8:4		17786		*117	7786*							Page 2
Item ID: Revision ID: Item Name:	D3580-1 Joggle Brace	cket		Accept	*N900	<u>0</u> 40	100)*	Setup	Start Stop	*N:	S1*
Start Date: Required Date: Reference:	5/02/14	Start Qty: 3.00 Req'd Qty: 3.00	*3*		Cust Item :						ı vı.	
Approvals:	Process I	Plan:		Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab	D	Operation Description Small Fab Mono Bend as per	dwg D3580 using 1/8 of	Set Up/ Run Hours 0.00 0.00 fset die	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC5- Inspect part comp	eteness to step on W/O	0.00	avul				-		,	
150 *1 \(\) \(\) Packaging		Identify as per dwg & St	ock Location:	0.00 (lavo	ey u	(Yd	5-02					

Memo

Packaging

Work Order ID 117786 *117786* Page 3 May-02-14 8:41:54 AM D3580-1 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop Joggle Bracket Item Name: **Start Date:** *3* Start Oty: 3.00 5/02/14 **Cust Item ID:** Required Date: 5/02/14 Req'd Oty: 3.00 Customer: Reference: Run Start Process Plan: Date: ____ Tooling: **Approvals:** Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Tool ID Operation Set Up/ Tool # Plan Reject Reject Insp. Accept Work Center ID Description Qty Oty Number Stamp Run Hours Code 160 QC21- Final Inspection - Work Order Release 0.00 SU-ZO-11 CUM *160*

0.00

Memo

oc.

Quality Control

N 140502

Picklist Print

May-02-14 8:41:53 AM

Work Order ID: 117786

D3580-1

117786 *D3580-1*

Parent Item Name: Joggle Bracket

Start Date: 5/02/14

Required Date: 5/02/14

Start Qty: 3.00

Required Qty: 3.00

Comments:

Parent Item:

IPP Rev : A New Issue 07.06.25 EC

IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	578.7100	0.01	1			
M304S18	RGA								**			J	M14-05-2

304/316 .050 Sheet

Location	Loc Oty	Loc Code	
MAT019	566.71		
117188	3		
117766	5		
120604	5		
122325	3		
123155	3		
124572	38		
M126647	39.75		
M128254	107.71		
M128435	187.25		
M128864	175		28864-
MAT020	12		
124029	2		
M126098	10		

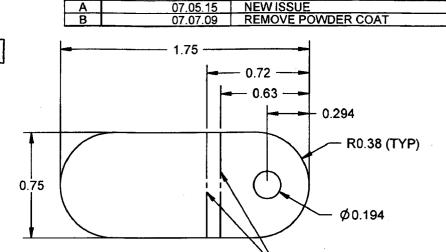


DESIGN	DRAWN BY	DART AEROSPA	CF ITD 7
16	CB	HAWKESBURY, ONTARIO	
	45550455	DRAWING NO.	<u> </u>
CHECKED	APPROVED		REV.`B
LE		D3580	SHEET 1 OF 1
DATE	1	TITLE	SCALE
07	.07.09	JOGGLE BRACKET	3:2

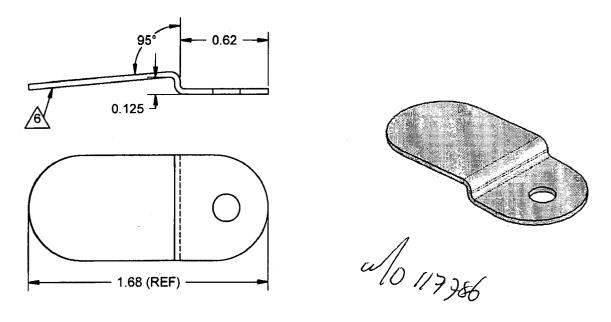
DESCRIPTION

BEND ON 0.03 RAD

RELEASED



D3580-1F FLAT PATTERN



D3580-1 JOGGLE BRACKET

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED

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DART AEROSPACE LTD	Work Order:	117786
Description: JOGGLE BRCKT	Part Number:	N 32804
Inspection Dwg: D3580 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194"	10.005-0.001	0196"	_		V	JAMUS.
0.294"	4-0-0:5	0.2969)		J	
1.75	41-02030	1.7484	_		J	
0.75	۸	0.753			U	
0.020,	4-0.010"	0-049*			V	
			·			
					,	,
						·
		,		<u> </u>	w	
			Die			

1	····					
	Measured by:	JM	Audited by:	9.89	Preliminary Approval:	
	Date:	14-05-2	Date:	14-05-02	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	*